

Date: Monday, 3/26/2007 2:59:37 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	RH ACTUATOR ASSEMBLY
Job Number	31451		
Estimate Number	12770		
P.O. Number	N/A	Part Number	41232 200 001 002
This Issue	3/26/2007	S.O. No.	41232-200-001 REV IR
Prsh Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	IR
Previous Run	N/A	Material	N/A
Written By		Due Date	4/2/2007
Checked & Approved By	JL 07.03.26	Qty:	5 Um: Each
Comment	Est Rev A New Issue 07-02-28 JLM		

Additional Product

Part Seq. #:	Machine Or Operation:	Description :	
1.001	MS208224	elbow	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
elbow			
Batch: M 103 688			SB 07/04/10
2.0	124K002 4CR 0545	Hose ass'y-Step Actuator	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Hose ass'y-Step Actuator			
BATCH: M 104 02			
3.0	AN8424D	Elbow	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Elbow			
Batch: M 104 04			
4.0	41232 200 007 001	Brass Cylinder Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Brass Cylinder Assembly			
Batch: B 30942			
5.0	41232 200 003 001	Spring (Step Actuator)	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Spring (Step Actuator)			
Batch: B 30941			JD 07/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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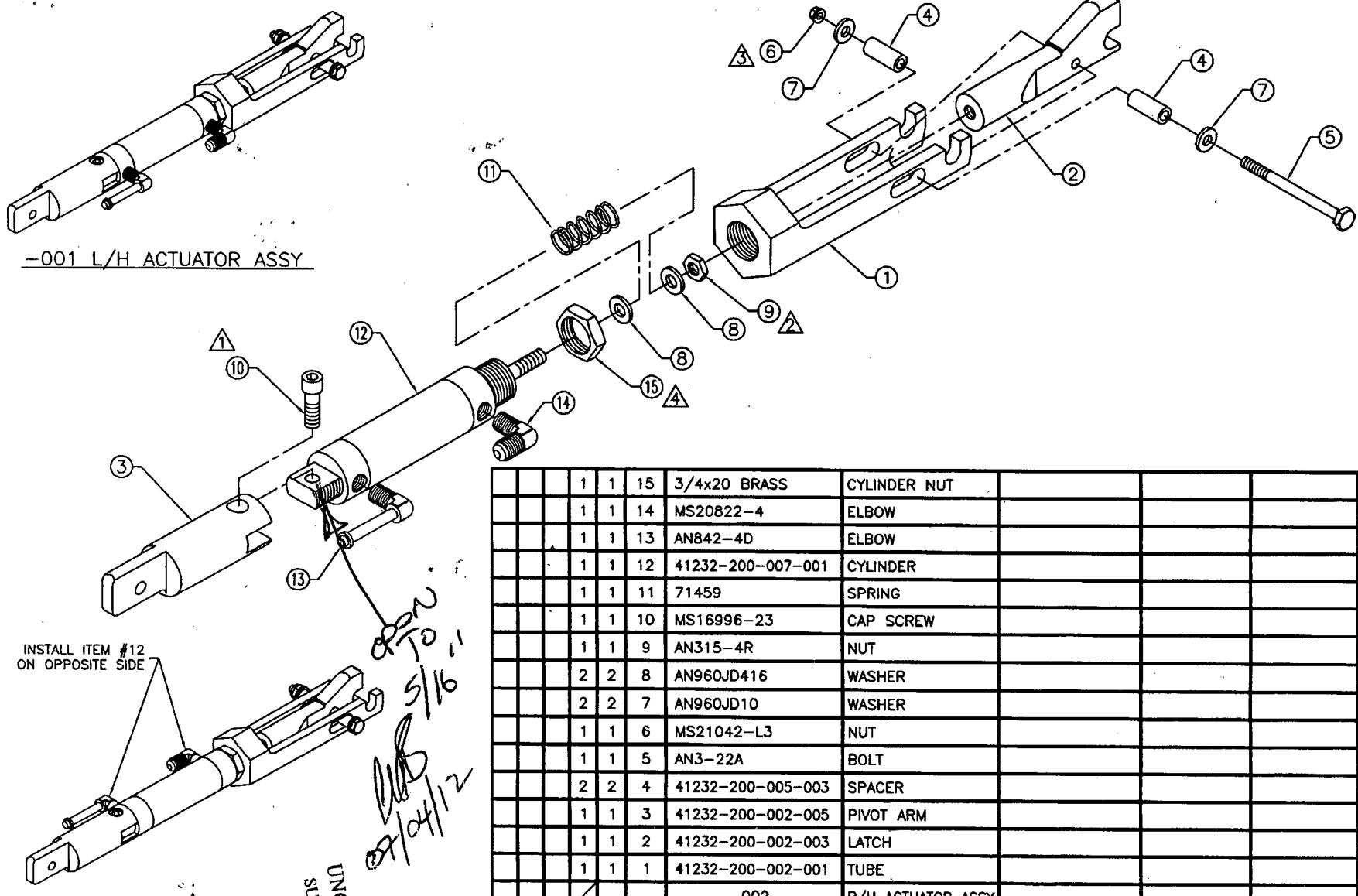
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: RH ACTUATOR ASSEMBLY
Job Number: 31451		Part Number: 41232 200 001 002
Job Number:		
Seq. #:	Machine Or Operation:	Description :
13.0.	41232 200 002 005	pivot arm
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) pivot arm Batch: B31021		
14.0.	41232 200 002 003	latch
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) latch Batch: B 31020		SB 07/04/10 (5)
15.0	41232 200 002 001	tube
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) tube Batch: B31019		SB 07/04/13 (5)
16.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per Dwg 41232-200-001 2-Torque as per Dwg 41232-200-001		SB 07/04/13 (5)
17.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		11/07/04/13 (5)
18.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		12/7/13 (5)
19.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		12/7/104/13 (5)
Job Completion		12/7/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- ⚠ TORQUE 80-100 IN.-LB.
- ⚠ TORQUE 20-25 IN.-LB.
- ⚠ TORQUE 50-75 IN.-LB.
- ⚠ TORQUE 50-75 IN.-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
31451

NO. REQ'D PER ASSY		PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC	ZONE
LIST OF MATERIAL							
PROPRIETARY RIGHTS NOTICE				UNLESS OTHERWISE SPECIFIED	DRAFTSMAN D. NELSON 5/20/02	TITLE	
THESE DATA ARE PROVIDED BY ERICKSON AVIATION, INC.				X±.1	CHECK D. MURPHY 5/20/02	STEP ACTUATOR ASSY	
EXCLUSIVELY FOR THE USE OF ERICKSON AVIATION, INC.				XX±.03	STRESS		
THESE DATA ARE FOR INTERNAL USE ONLY AND				XXX±.010	PROL. ENGR.	DWG. SIZE C	SCALE NONE
NOT FOR RELEASE OUTSIDE ERICKSON AVIATION, INC.				ANGLES ±.1/2	HEAT TREAT	DWG. NO. 41232-200-001	REV. IR
THESE DATA ARE NOT APPLICABLE TO VENDOR PARTS.		NEXT ASSEMBLY	REL.	FINISH	<i>Erickson Aviation, Inc.</i>		
PRINTED NO. 002-001	PRINTED DATE 2/4/12						